

Work Order ID 104673

104673

Page 1

Friday, July 12, 2013 12:41:09 PM

Item ID: D3507-1-BENT

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube Assembly EC135

Start Date: 7/12/2013 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/18/2013 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

PL

Date: *7-07-13*

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3507

Rev C

120

0.00

120

BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1- Bend tube as per program D3507 on CNC Bender FOLIO 6 and Dwg D3507,
use DT9632 bending aide
2- Cut FWD END of tube as per dwg D3507

De 13/09/05

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

DP 13-9-5

300

Identify as per dwg & Stock Location: *46*

0.00

300

Packaging

Packaging

Memo

0.00

Packaging

DP 13-9-5 *(2)*

Work Order ID 104673***104673***

Page 2

Friday, July 12, 2013 12:41:09 PM

Item ID: D3507-1-BENT

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube Assembly EC135

Start Date: 7/12/2013 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/18/2013 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

310

QC21- Final Inspection - Work Order Release

0.00

310

QC

Memo

0.00

Quality Control

13/9/9

H 13 07 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </td> <td style="width: 33%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </td> <td style="width: 33%;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </td> <td style="width: 33%;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </td> </tr> </table>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--

Picklist Print

Friday, July 12, 2013 12:41:13 PM

Page 1

Work Order ID: 104673

104673

Parent Item: D3507-1-BENT

D3507-1-BENT

Parent Item Name: Skidtube Assembly EC135

Start Date: 7/12/2013

Required Date: 7/18/2013

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 10.09.17 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2962-150		Manufactured	No			100	Each	111.0000	1	2			

D2962-150

3.540 Outer Tube, Extrud

**

DP 13-9-5

Location

Loc Qty

Loc Code

HALL

111

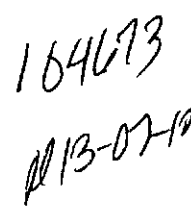
59934

16

90871

95

2



Technical drawing of a shaft assembly. The shaft has a total length of 109.50. Key dimensions and features include:

- Left End:** A hole with a diameter of $\varnothing 0.209$ THRU, located 1.59 from the end. A fillet with a radius of 0.40 transitions to the main shaft.
- Top Surface:** A feature with a diameter of $\varnothing 0.750$ THRU (2 PLACES) and a fillet radius of 0.40.
- Top Surface Only:** A feature with a diameter of $\varnothing 0.297$ TOP SIDE ONLY.
- Internal Features:** Three circular features with diameters of $\varnothing 0.500$ THRU, $\varnothing 0.375$ THRU, and $\varnothing 0.500$ THRU. Their positions are defined by distances of 17.690, 35.380, and 59.07 from the left end.
- Right End:** A hole with a diameter of $\varnothing 0.209$ THRU, located 0.40 from the end.
- Detail A:** A callout pointing to the left end of the shaft.

0.500

0.500

Ø0.128
(2 PLACES)

Ø0.500 OR
Ø0.375
(REF)

DETAIL A
(TYP, 6 PLACES)
SCALE 3:10

- 1) FINISH:
CHEMICAL CONVERSION COAT P2R DART QSI 005 4.1 PRIOR TO INSERTING
D3505-1 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART
QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER
DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND
WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER
DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT886B TO LOCATE AND DRILL Ø0.297 HOLES (38
PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38
PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED
LOCATIONS

RELEASED
07-11-16

C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	OC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MATL	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE USA, INC	
DRAWN	<i>JIC</i>	PORT HADLOCK, WA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>GP</i>	D3507	SHEET 1 OF
APPROVED	<i>GP</i>	TITLE	SCALE
DE APPR.	<i>GP</i>	EC 135 SKIDTUBE	NT
DATE	07.09.19	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PROPERTY AND CONFIDENTIAL, AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	

